



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 181108



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/20/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/17/18	0.00	0.00	Start Up Large Fab-5		2018-08-16
100	Large Fab	1 pcs		8/17/18	0.00	10.00	Large Fab 1		2018-08-22
110	QC	1 pcs		8/17/18	0.00	0.00	QC9		2018-08-27
120	QC	1 pcs		8/17/18	0.00	0.00	QC5		2018-08-27
125	HandFinish	1 pcs		8/17/18	0.00	0.29	HandFinish2		2018-08-29
130	Powdercoat	1 pcs		8/17/18	0.00	0.93	Powdercoat2		2018-08-29
140	QC	1 pcs		8/17/18	0.00	0.00	QC3		2018-08-28
150	HandFinish	1 pcs		8/17/18	0.00	0.50	HandFinish4		2018-08-28
160	QC	1 pcs		8/17/18	0.00	0.00	QC5		2018-08-29
170	Packaging	1 pcs		8/17/18	0.00	0.00	Packaging3-2		2018-08-29
180	QC21-SA	1 Ea		8/17/18	0.00	0.00	QC21		2018-08-29

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 83893

START: 8:45

CUT: 3:30 FINISH: 9:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	2078989
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	2096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	2093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	2080994
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	2096603
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	2084677
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	20101510
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	2093147
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	2094864
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	2068796
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	2091241
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	2083610
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	2070373

1000

1000
1000
1000

1000
1000
1000

D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	2100984
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	2100985
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	3089950
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5070545
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5089298-1
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	FR6435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	FM137412-2
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5078253
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5103666-1
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5072828

* NAS1149DN8325 washer 2Ea(ea) 150 HandFinish 5034411-1 *

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	53	0
	D3913-1	1	3	0
	D3913-15	1	22	0
	D3913-3	1	4	0
	D3913-7	2	6	0
	D3913-9	1	8	0
	D3916-041	2	12	0
	D3916-5	3	33	0
	D4016-1	3	28	0
	D4017-7	3	25	0
	D4017-9	2	12	0
	D4020-11	2	13	0
	D4021-1	3	51	0
	D4034-041	1	6	0
	D4034-043	1	5	0
	D4672-1	2	20	0
	M304EX0.75-16F	33	1,473	0
150-HandFinish	AN3-10A	6	225	0
	D2931	2	992	0
	D4021-5	2	44	0
	MS20600-AD4W3	2	259	0
	MS21042L3	6	1,669	0
	NAS1149F0332P	12	1,299	0

Part Specifications

Specifications could not be found.

Plex 7/20/18 1:21 PM Dart.lajeunesse.marie

MU. 005226



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S103014



Part: D3913-041

Job No: 181108

Serial No/Batch: S103014

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/16/18